

ABSTRACT OF THE DISCLOSURE

A method and a device are proposed which accurately and efficiently form a pipe with a bending machine only without using any correcting means. A work having holes is fed into a bending machine in which under an upper roll, lower rolls parallel thereto are arranged and a pipe is formed with rough forming step and fine forming step. In the rough forming step, bending is done so that it will have a required diameter at the hole portions. In the fine forming step, the hole portions are not pressed for bending while the other portions are rolled so as to become closer to the required diameter to form the pipe.